



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

European warehouse
Ship July 15

004141

647.3702

Job Sheet 179840



Part No: 647.3702

Job Qty: 1 ea

Part Name: 412 Cable Cutter System, High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 7/25/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG 647.3700 REV:A IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.26 as per ecr 14-214 DD VERF:JLM IPP REV:C AS PER REV NC3 15.03.18 JLM VERIFIED BY:DD IPP REV:D 18.01.19 AS PER DWG REV:A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/25/18	7/25/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 28 2018
110	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging1-1		JUN 28 2018
120	QC	1 pcs	7/25/18	7/25/18	0.00	0.00	QC4		SMB
125	DC	1 pcs	7/25/18	7/25/18	0.00	0.00	DC		SMB
130	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging3-1		SMB
140	QC21-FG	1 Ea	7/25/18	7/25/18	0.00	0.00	QC21		JUL 30 2018

Part Op 125 - Photocopy bluefile & type labels per PPP 647.3702
Descriptions: 130 - Identify and pack for shipping as per PPP 647.3702

Job BOM

EXP.
18/12/3
06/19
163032

N/C

x 7

5074834x23

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5085283
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5032768
601.3073	Connector p/n 082-4440	1 Ea (1 ea)	90-Start up Operation	5054871
601.3083	Adhesive Rubber Seal	1 Ea (1 ea)	90-Start up Operation	5064985
647.3801	412 Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5060713
647.3804	204,205,212,214,412 Lower Cutter Assembly High	1 Ea (1 ea)	90-Start up Operation	5034441
647.3903	Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	5158472
647.4010	Wiper Deflector RH	1 Ea (1 ea)	90-Start up Operation	5062598
647.4011	Wiper Deflector LH	1 Ea (1 ea)	90-Start up Operation	5004312
647.4110	Doubler	1 Ea (1 ea)	90-Start up Operation	5161210
647.4111	Doubler	1 Ea (1 ea)	90-Start up Operation	5162469
647.4112	Clip	1 Ea (1 ea)	90-Start up Operation	5163483
647.4113	Clip	1 Ea (1 ea)	90-Start up Operation	5026930
647.4114	Shim	2 Ea (2 ea)	90-Start up Operation	5026933
647.4115	Shim	2 Ea (2 ea)	90-Start up Operation	5158448
647.4116	Shim	1 Ea (1 ea)	90-Start up Operation	5161755
647.4210	Bracket LH	1 Ea (1 ea)	90-Start up Operation	5161789
647.4211	Bracket RH	1 Ea (1 ea)	90-Start up Operation	5158229
647.4310	LH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5161672
647.4311	RH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5162492
647.4312	LH Upper Strut	1 Ea (1 ea)	90-Start up Operation	5158436
647.4313	RH Upper Strut	1 Ea (1 ea)	90-Start up Operation	5155358
647.4410	Rail	1 Ea (1 ea)	90-Start up Operation	5027721
AN3-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5060063
AN3-4A	Bolt	3 Ea (3 ea)	90-Start up Operation	5019323
AN3C10A	Bolt	2 Ea (2 ea)	90-Start up Operation	5082912
CCR264SS-3-03	Cherry Rivet	16 Ea (16 ea)	90-Start up Operation	5043715
CCR264SS3-04	Rivet	12 Ea (12 ea)	90-Start up Operation	5000546
CR3212-4-2	Cherry Rivet	12 Ea (12 ea)	90-Start up Operation	5053949
CR3212-4-3	Cherry Rivet	17 Ea (17 ea)	90-Start up Operation	514138120
CR3212-4-4	Cherry Rivet	4 Ea (4 ea)	90-Start up Operation	5019424
CR3213-4-2	Cherry Rivet	13 Ea (13 ea)	90-Start up Operation	5027731
CR3213-4-3	Rivet, Cherry	32 Ea (32 ea)	90-Start up Operation	5048830
CR3213-4-4	Rivet, Cherry	19 Ea (19 ea)	90-Start up Operation	5019315
CR3213-4-5	Rivet	42 Ea (42 ea)	90-Start up Operation	514136983-5
CR3213-4-8	Rivet	4 Ea (4 ea)	90-Start up Operation	5046234
MS21042-08	Use Ms21042L08	18 Ea (18 ea)	90-Start up Operation	5078167
MS21042-3	Nut use MS21042L3	79 Ea (79 ea)	90-Start up Operation	5084882
MS21047-3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	514138408
MS21047L06	Nut Plate	6 Ea (6 ea)	90-Start up Operation	5016504
MS21047L08	Nut Plate	6 Ea (6 ea)	90-Start up Operation	514137680-0
MS21071L3	Anchor Nut	4 pcs (4 ea)	90-Start up Operation	514137951-7
MS24694-C53	Screw	8 Ea (8 ea)	90-Start up Operation	51429702
MS24694-S49	Screw	1 Ea (1 ea)	90-Start up Operation	5053952
MS27039-08-08	Screw	16 Ea (16 ea)	90-Start up Operation	514138336-10
MS27039-08-11	Screw	2 Ea (2 ea)	90-Start up Operation	5079112
MS27039-1-07	Screw	12 Ea (12 ea)	90-Start up Operation	5017101
MS27039-1-09	Screw	14 Ea (14 ea)	90-Start up Operation	5061228x13
MS27039-1-10	Screw	42 Ea (42 ea)	90-Start up Operation	5074834x23
NAS1149F0332P	Washer	157 Ea (157 ea)	90-Start up Operation	5071415
NAS1149FN832P	Washer	34 Ea (34 ea)	90-Start up Operation	514138336-9

5084888x6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	28	0
	601.2045	1	19	0
	601.3073	1	4	0
	601.3083	1	4	0
	647.3801	1	2	0
	647.3804	1	2	0
	647.3903	1	1	0
	647.4010	1	11	0
	647.4011	1	9	0
	647.4110	1	5	0
	647.4111	1	4	0
	647.4112	1	13	0
	647.4113	1	7	0
	647.4114	2	11	0
	647.4115	2	11	0
	647.4116	1	18	0
	647.4210	1	10	0
	647.4211	1	10	0
	647.4310	1	13	0
	647.4311	1	3	0
	647.4312	1	6	0
	647.4313	1	6	0
	647.4410	1	5	0
	AN3-11A	8	135	0
	AN3-4A	3	288	0
	AN3C10A	2	23	0
	CCR264SS-3-03	16	244	0
	CCR264SS3-04	12	122	0
	CR3212-4-2	12	36	0
	CR3212-4-3	17	158	0
	CR3212-4-4	4	290	0
	CR3213-4-2	13	146	0
	CR3213-4-3	32	148	0
	CR3213-4-4	19	496	0
	CR3213-4-5	42	172	0
	CR3213-4-8	4	128	0
	MS21042-08	18	0	0
	MS21042-3	79	95	0
	MS21047-3	4	138	0
	MS21047L06	6	29	0
	MS21047L08	6	21	0
	MS21071L3	4	61	0
	MS24694-C53	8	59	0
	MS24694-S49	1	156	0
	MS27039-08-08	16	96	0
	MS27039-08-11	2	1,393	0
	MS27039-1-07	12	98	0
	MS27039-1-09	14	150	0
	MS27039-1-10	42	411	0
	NAS1149F0332P	157	1,638	0
	NAS1149FN832P	34	1,294	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

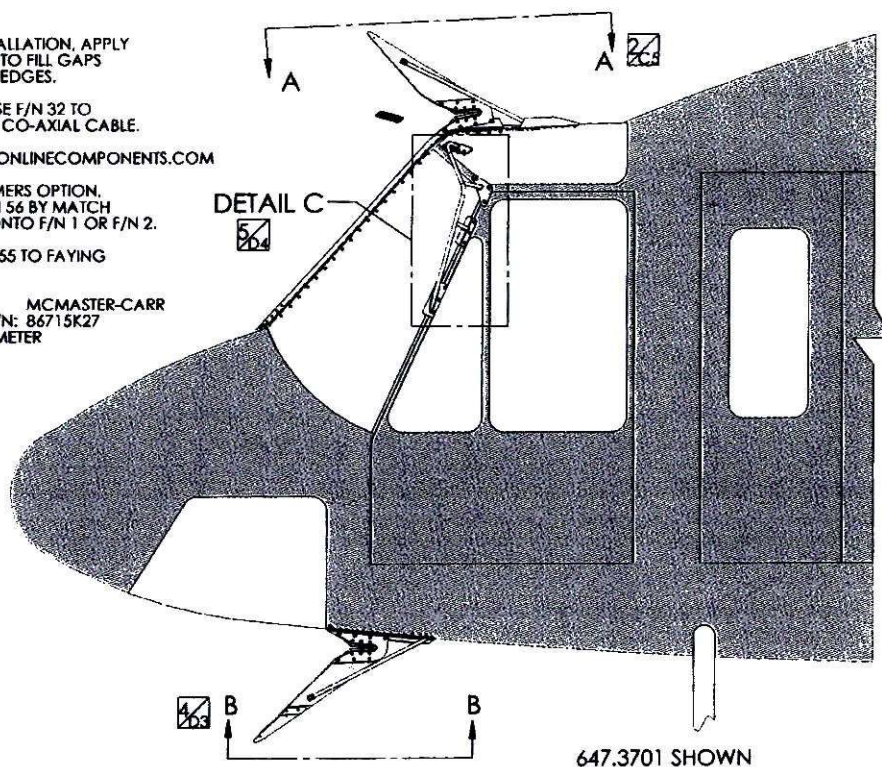
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date: _____ Step _____		QTY Effective: _____		MRB (QS1042) Approval	
Description Work Order		Completed By		Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Root Cause No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		QC / QA Coordinator Approval	
Cracks Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Inspection Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Other Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	

DART AEROSPACE
 Container No: S085286
 Part: 647.3702
 Job No: 179840
 Serial No/Batch: S085286
 Revision: A
 Inspector:
 Exp Date:
 Instructions:
 Date: 06/26/10

REFERENCE ONLY

NOTES:

- 1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
- 2 IF REQD. USE F/N 32 TO CONNECT CO-AXIAL CABLE.
- 3 VENDOR : ONLINECOMPONENTS.COM
- 4 AT CUSTOMERS OPTION, INSTALL F/N 56 BY MATCH DRILLING ONTO F/N 1 OR F/N 2.
- 5 APPLY F/N 55 TO FAYING SURFACES.
- 6 VENDOR : MCMMASTER-CARR
VENDOR P/N: 86715K27
60A DIUMETER



647.3701 SHOWN

[illegible]

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION PR1		N/C
N/C	INITIAL RELEASE	09-29-09	P BRAVO
A	INCORPORATED ICH02728 04881 04845 & 05063	12-15-17	P BRAVO

[illegible]

QTY	UNIT PRICE	TOTAL PRICE
1	100.00	100.00
2	200.00	400.00
3	300.00	900.00
4	400.00	1600.00
5	500.00	2500.00
6	600.00	3600.00
7	700.00	4900.00
8	800.00	6400.00
9	900.00	8100.00
10	1000.00	10000.00
11	1100.00	12100.00
12	1200.00	14400.00
13	1300.00	16900.00
14	1400.00	19600.00
15	1500.00	22500.00
16	1600.00	25600.00
17	1700.00	28900.00
18	1800.00	32400.00
19	1900.00	36100.00
20	2000.00	40000.00
21	2100.00	44100.00
22	2200.00	48400.00
23	2300.00	52900.00
24	2400.00	57600.00
25	2500.00	62500.00
26	2600.00	67600.00
27	2700.00	72900.00
28	2800.00	78400.00
29	2900.00	84100.00
30	3000.00	90000.00
31	3100.00	96100.00
32	3200.00	102400.00
33	3300.00	108900.00
34	3400.00	115600.00
35	3500.00	122500.00
36	3600.00	129600.00
37	3700.00	136900.00
38	3800.00	144400.00
39	3900.00	152100.00
40	4000.00	160000.00
41	4100.00	168100.00
42	4200.00	176400.00
43	4300.00	184900.00
44	4400.00	193600.00
45	4500.00	202500.00
46	4600.00	211600.00
47	4700.00	220900.00
48	4800.00	230400.00
49	4900.00	240100.00
50	5000.00	250000.00
51	5100.00	260100.00
52	5200.00	270400.00
53	5300.00	280900.00
54	5400.00	291600.00
55	5500.00	302500.00
56	5600.00	313600.00
57	5700.00	324900.00
58	5800.00	336400.00
59	5900.00	348100.00
60	6000.00	360000.00
61	6100.00	372100.00
62	6200.00	384400.00
63	6300.00	396900.00
64	6400.00	409600.00
65	6500.00	422500.00
66	6600.00	435600.00
67	6700.00	448900.00
68	6800.00	462400.00
69	6900.00	476100.00
70	7000.00	490000.00
71	7100.00	504100.00
72	7200.00	518400.00
73	7300.00	532900.00
74	7400.00	547600.00
75	7500.00	562500.00
76	7600.00	577600.00
77	7700.00	592900.00
78	7800.00	608400.00
79	7900.00	624100.00
80	8000.00	640000.00
81	8100.00	656100.00
82	8200.00	672400.00
83	8300.00	688900.00
84	8400.00	705600.00
85	8500.00	722500.00
86	8600.00	739600.00
87	8700.00	756900.00
88	8800.00	774400.00
89	8900.00	792100.00
90	9000.00	810000.00
91	9100.00	828100.00
92	9200.00	846400.00
93	9300.00	864900.00
94	9400.00	883600.00
95	9500.00	902500.00
96	9600.00	

NEXT ASSY IS

PARTS LIST

ORIGINAL DATE (MO-DA-YR)	08-29-09
DRAWN BY J. JACKSON	C D.
DRAWING APPROVAL P. BRAVO	
CONTRACT NO.	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
FRACTIONS ±.01

DART
3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081-8347
1760124-5300

412 CABLE CUTTERS KIT

SEE B	CAGE CODE 07M26	DRG. NO. 647.3700	REV. A
SCALE NONE		SHEET 1 OF 5	